

Work Order ID 55474

January 19, 2010 12:53:41 PM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Item Name: 350 Basket Base

Stop



Start Date: 1/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *10-1-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								
100	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: <i>H10A215</i>								<i>AD 10.02.03</i>
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

10/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 1/25/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

8/10/02/04



QC

Memo

0.00

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel
PRESSURE WASH

0.00

=> 11/10/02/02



Powdercoat

Memo M113170

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: 8:30am

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:00am

***** 2nd coat if necessary*****

2ND COAT:

START TIME: 9:30am

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:00am

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-02-9 @ 10.00

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

W/O 55473

BR 10-02-9 @ 10.00

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/09 @ 10.00
MF 10-2-9

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 55474



Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 1/20/2010

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Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2221-1

Manufactured No 100 Each 13.0000 1.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1

48101 1

Main Warehouse

WA 12

53662 12

PD 10.02.01

D2221-5

Manufactured No 100 Each 10.0000 2.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA 10

53656 2

54204 8

PD 10.02.01

D2221-7

Manufactured No 100 Each 5.0000 1.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA 5

53659 1

54205 4

PD 10.02.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D2232-3



Basket Hinge

Manufactured No 100 Each 35.0000 2.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 30

50024 2

54863 28

PD 10.02.02

Main Warehouse

WA 5

53831 5

✓ D2235-1



Basket Rib

Manufactured No 100 Each 12.0000 2.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA 12

50565 3

54206 9

B 54864 PD 10.02.01

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 49.0000 2.0000



Mounting Bracket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	46	
46086	2	
48428	1	
51120	2	
54862	41	

PD 10.02.03

Main Warehouse

WA	3	
50872	1	
51745	2	

D3442-1 Manufactured No 100 Each 24.0000 2.0000



Shim

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1	
46767	1	

Main Warehouse

WA	23	
53386	5	
54071	18	

PD 10.02.02
 PD 10.02.02

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D3825-041



Rib Assembly (Basket End)

Manufactured No 100 Each 4.0000 2.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

4

53902

4

B54865 PD 10.02.01

D3826-041



Rib / Gusset Assembly

Manufactured No 100 Each 6.0000 2.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

6

53721

2

54657

4

PD 10.02.01

✓ D3827-041



Rib Assembly (Inboard)

Manufactured No 100 Each 7.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7

53661

1

53901

6

PD 10.02.01

January 19, 2010 12:53:41 PM

Shop Packet Print

Page 4

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

D3832-1



Manufactured No

100

Each

1.0000

1.0000



Mesh (Base)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

53874

1

B54728

PD 10.02.03

D3833-1



Manufactured No

100

Each

14.0000

2.0000



Mesh (Base End Face)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

14

50025

2

53214

2

54074

2

54278

8

PD 10.02.03

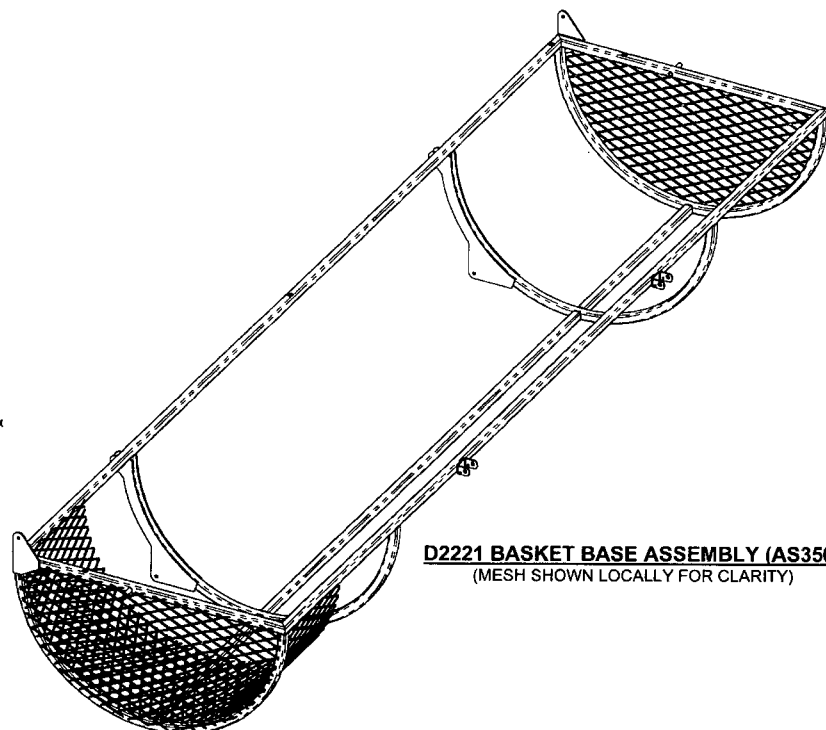
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

55474

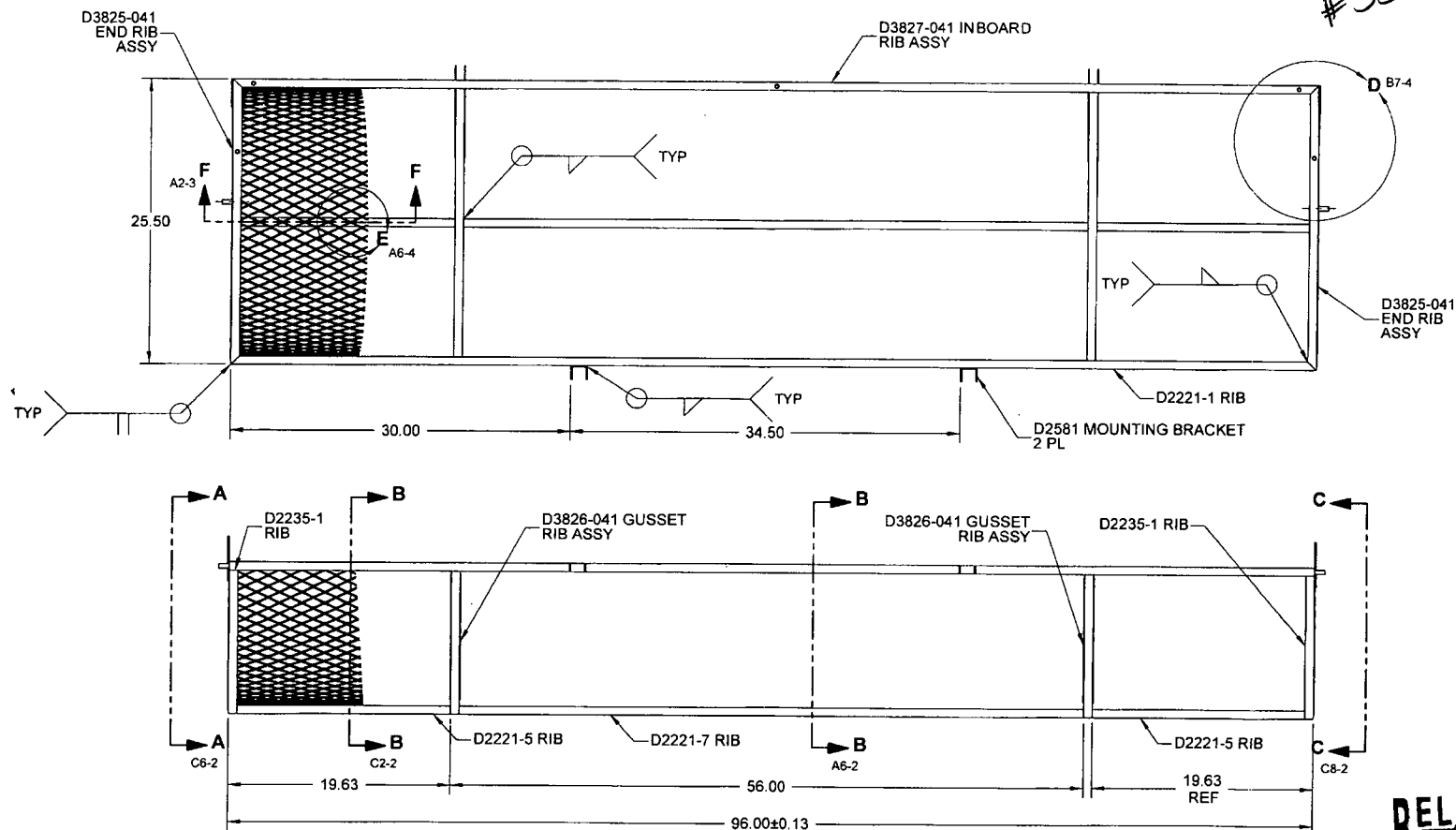
ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RECEIVED
08/11/19

NOTES:






- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

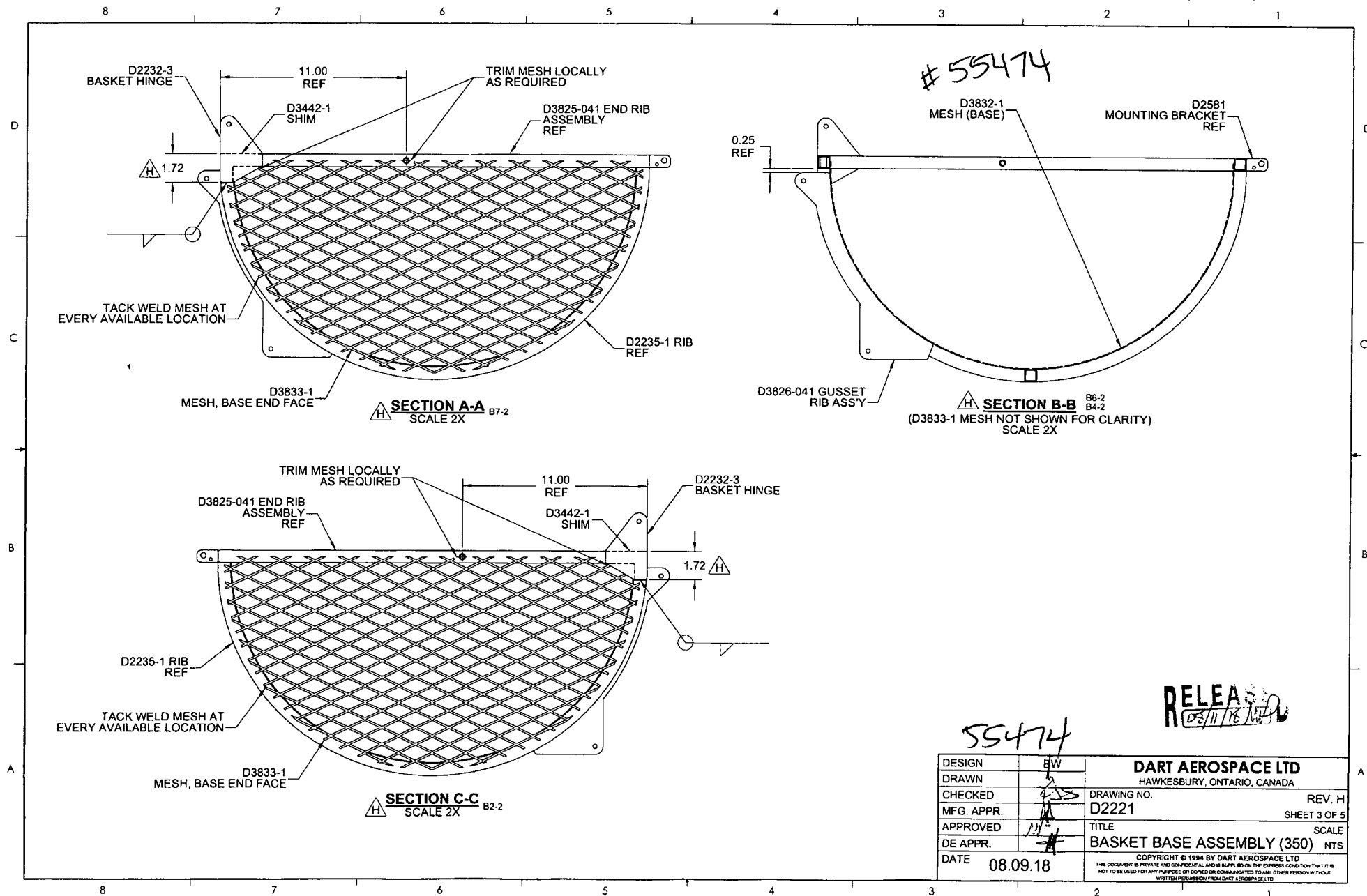
H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR 1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.05.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

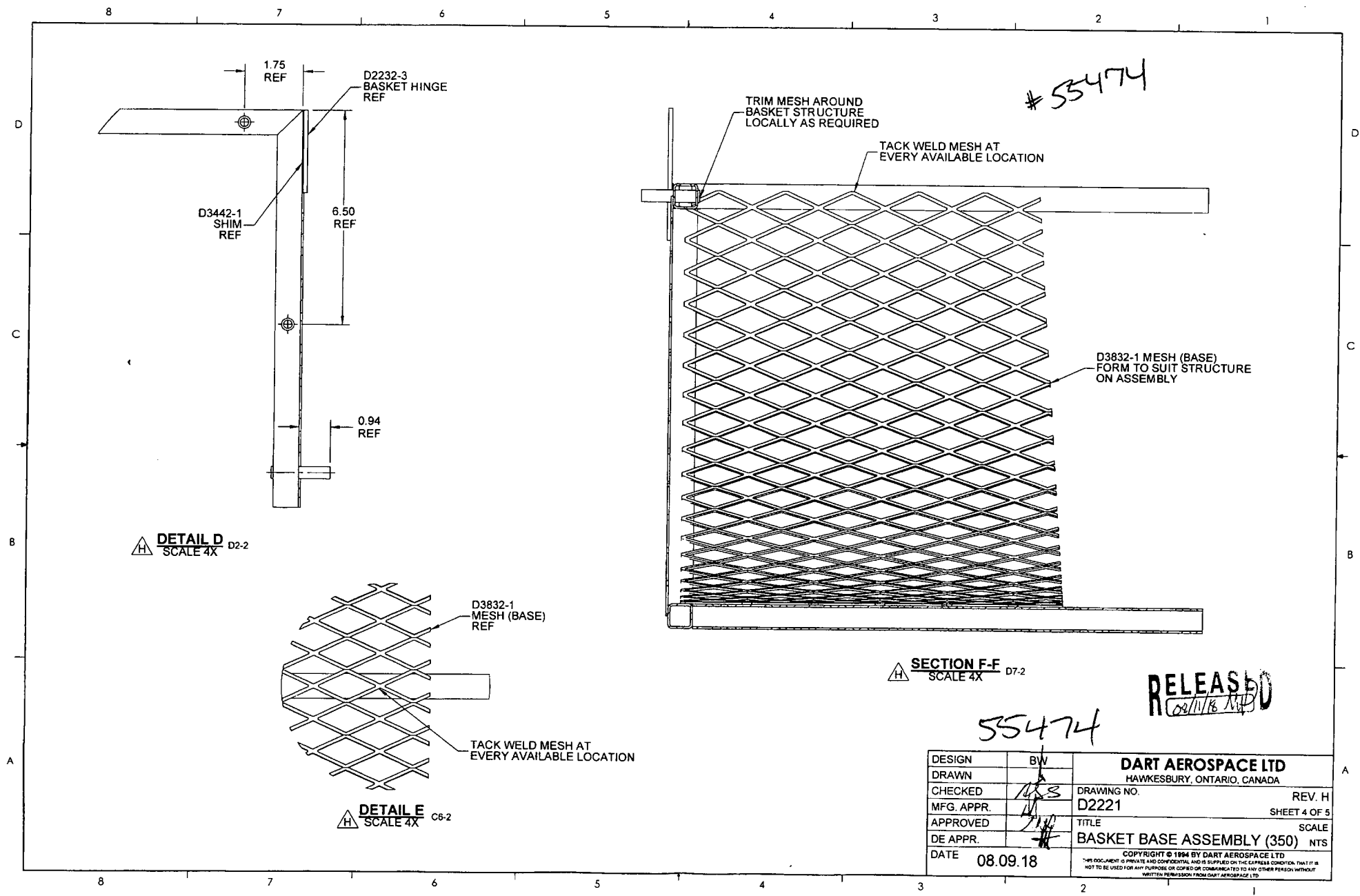
RELEASED
06/11/18 NAD
55474

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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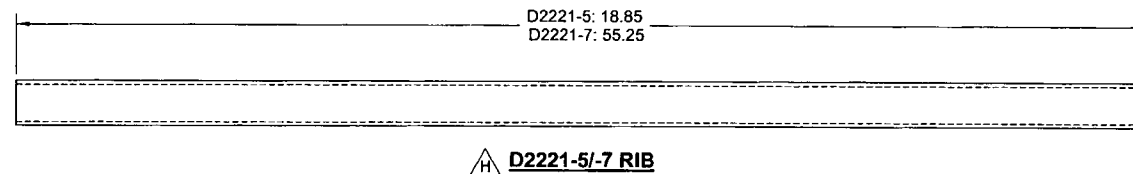
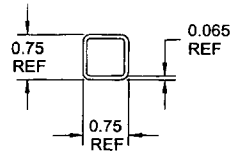
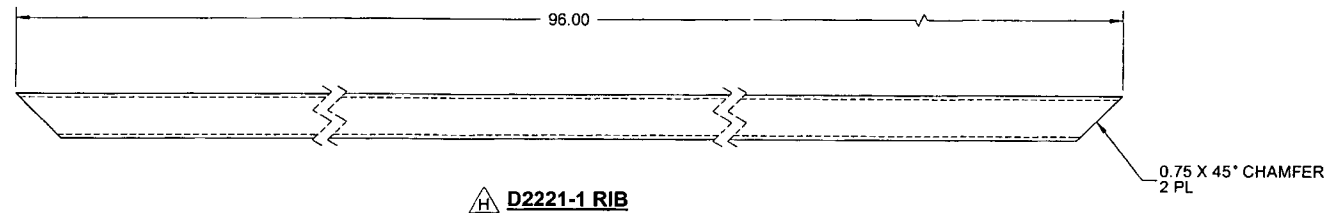
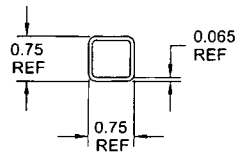


55474

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	23		
CHECKED	11	DRAWING NO. D2221	REV. H
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASSEMBLY (350) NTS	
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD	
DATE	08.09.18	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



#55474



RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASD		
CHECKED	ASD	DRAWING NO. D2221	REV. H SHEET 5 OF 5
MFG. APPR.	ASD	TITLE	SCALE
APPROVED	ASD	BASKET BASE ASSEMBLY (350)	NTS
DE APPR.	ASD	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.18		